

Date: Thursday, 06/11/2008 3:14:33 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 43250			Part Number	: D2596		
Estimate Number	: 10346			Drawing Number	: D2596 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/11/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SKIDTUBES	Due Date	: 13/11/2008		
Previous Run	: 43108			Qty:	4	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08 11.06</u>						
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D25003100	Ext'n -'I' Beam Web 4"		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"				
	Pick;	Qty	Part Number	Description
		1	D2500-3-100	Extrusion
				Batch <u>40196</u> SL 8-11-7
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1		
				
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr				
				SL 8-11-7
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
				
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1				
				SL 8-11-7
4.0	QC5	INSPECT WORK TO CURRENT STEP		
				
Comment: INSPECT WORK TO CURRENT STEP				
				 8-11-7 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 8-11-7

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/08 JF

Job Completion



JF 08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

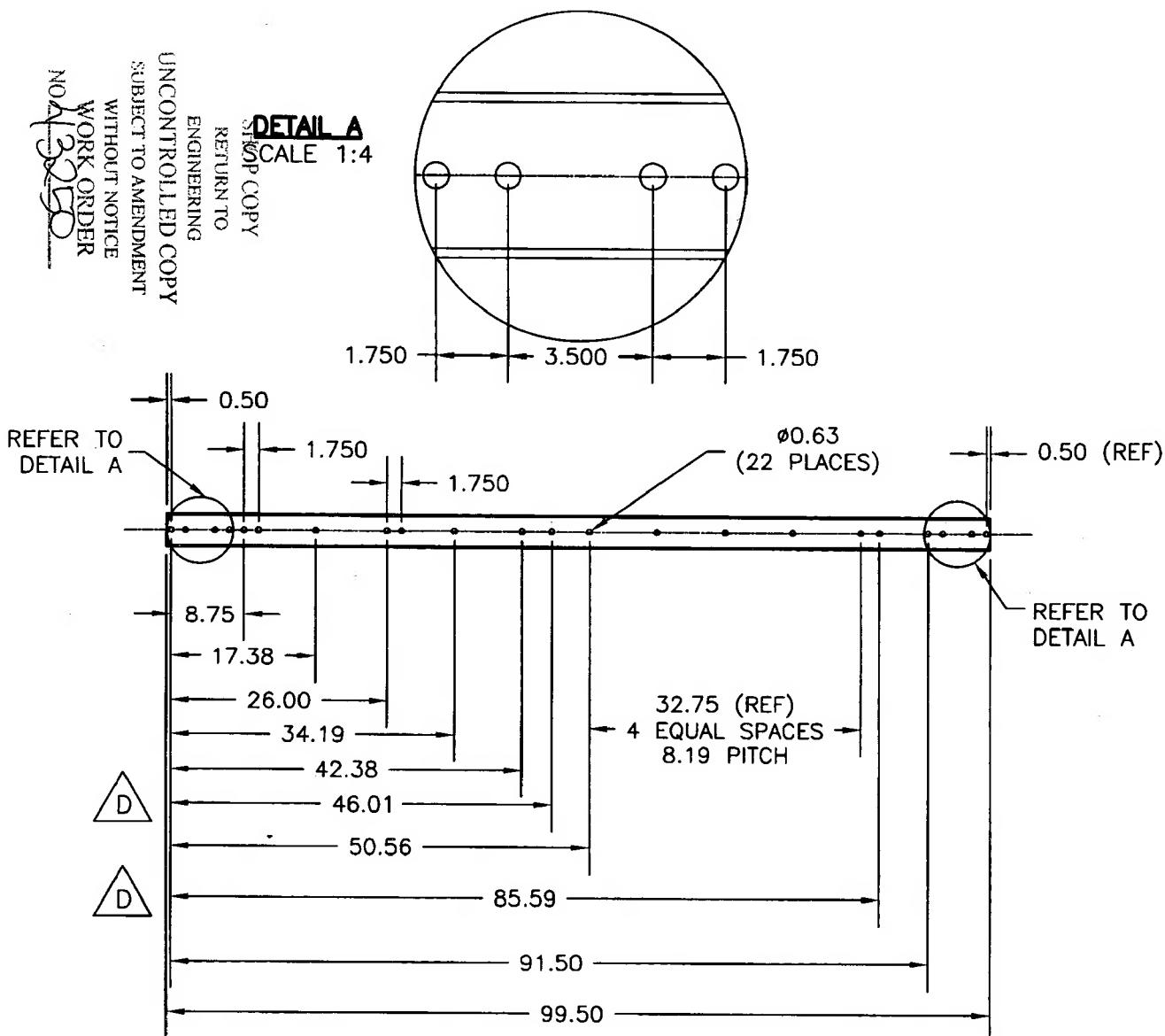
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

DESIGN <i>RH</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D2596
DATE 07.04.17	TITLE 205 WEB	REV. D SHEET 1 OF 1
A	96.09.16	NEW ISSUE
B	97.07.23	$\phi 0.63$ HOLE WAS $\phi 0.56$
C	98.09.14	INCORPORATED DEO 9097
D	07.04.17	INCORPORATED DEO 9183

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020